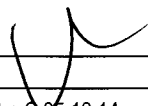
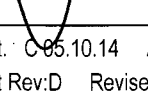


Date: Friday, 30/11/2007 8:21:54 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR ASSEMBLY
 Job Number : 36073
 Estimate Number : 11403
 P.O. Number : N/A Part Number : D3296041
 This Issue : 30/11/2007 S.O. No. : N/A Drawing Number : D3296 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 35213 Material : N/A
 Due Date : 07/12/2007 Qty: 22 Um: Each
 Written By : 
 Checked & Approved By : 
 Comment : Est. C 05.10.14 Added step 14 KJ/EC
 Est Rev:D Revised Steps 06-11-20 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32961 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1 D3296-1 Door Panel B 35232

SD 07/11/30 (22)

2.0 D32963 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1 D3296-3 Door Panel B 35233

SD 07/11/30 (22)

3.0 D31617 Hinge 14"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Hinge 14"

Batch: B36082 x22

ml 07/12/04

4.0 D31619 Hinge 17"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Hinge 17"

Batch: B35229 (4)


B 35504 (10)

* B36083 x 8 ml 07/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:21:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36073

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 550.0000 Each(s)

Rivet, Universal Head

Batch: M105108

m107/12/05

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

m107/12/05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/12/06 x

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 07/12/06

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-06

22x

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Decal - No Step

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	B35606

15p / B 36227 x 7 m107/12/05

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	B33186

4p

C

B36080 15p

B36228 3x

~~B36227~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/06	#60	Door Assembly doesn't move with ease. RC Hinge is too far on one panel.		Drill out all 18 Reuts along D3161-9. Reut touch up along if necessary.	 07/12/06 07/12/06			
				Reinstall D3161-7 B# <u>36083</u> Reut ms20470AD4-4 18x B# <u>M105108</u> 18x	 07/12/06			
07/12/06	10	Scrap 2 label D2137 when put on door. RC Hemman error		Tried to took off before scrap 2 label D2137 take 2 new in stock B36007	 07/12/06			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:21:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36073

Part Number: D3296041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	D24620040	Seal
------	-----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462-0040	Seal	29256
---	------------	------	-------

2.3

13.0	D24620053	Seal
------	-----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462-0053	Seal	29456
---	------------	------	-------

9.7

14.0	D24620245	Seal
------	-----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462-0245	Seal	329456
---	------------	------	--------

4.50

15.0	D27281	Dart Logo label small
------	--------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Dart Logo label small

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2728-1	Decal	329215
---	---------	-------	--------

16.0	AN960JD6	Washer
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	AN960JD6	Washer	M6285
---	----------	--------	-------

7/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:21:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36073

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M105408

7/12/07 (22)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

X22

PTO

ml 07/12/20

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/20 (22)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 217

AS 07/12/21 (22)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LD 07/12/24

Job Completion



U 07/12/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/11	18	Bad install of rivet MS 20470-4-6. Make Hole bigger than in the door took out.	Q51042	Replace door D3296-3 by new one B 35233 and new 9 rivets MS 20470 AD 4-4 M105108		Q51042	Q51042	Q51042
			Q51042	Replace door D3296-3 by new one B 35233 and new 9 rivets MS 20470 AD 4-4 M105108	07/12/11	Q51042	Q51042	Q51042
				Re-paint Black Door Q51005 M100700	07-12-12			

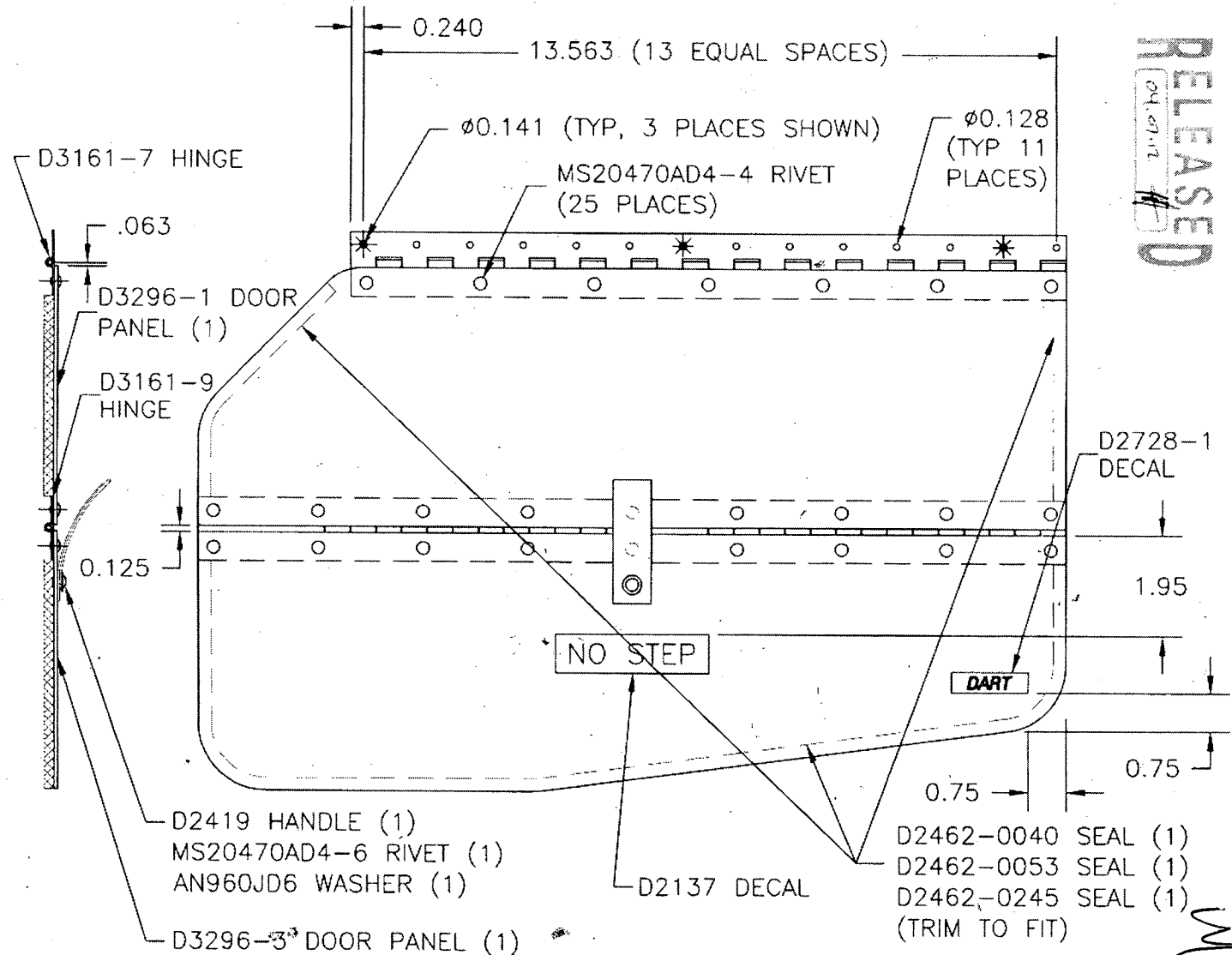
NOTE: Date & initial all entries

DART



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3296
DATE 04.06.28	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	SCALE 1:3
	NEW ISSUE	



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE.
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

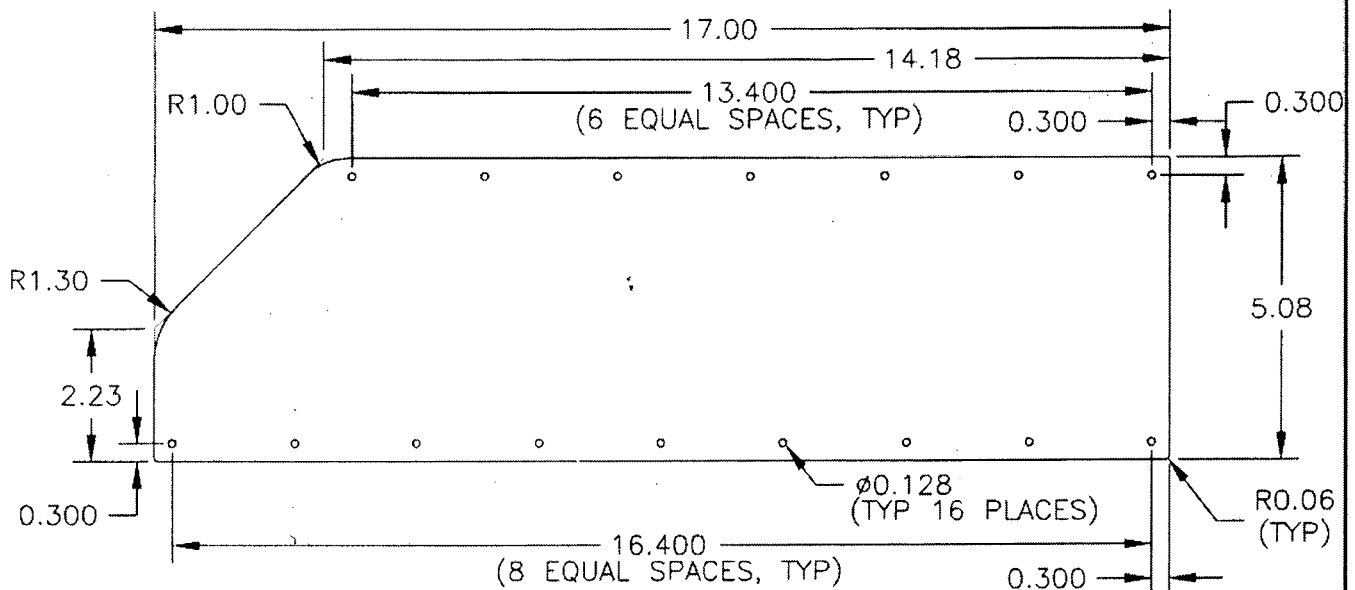
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

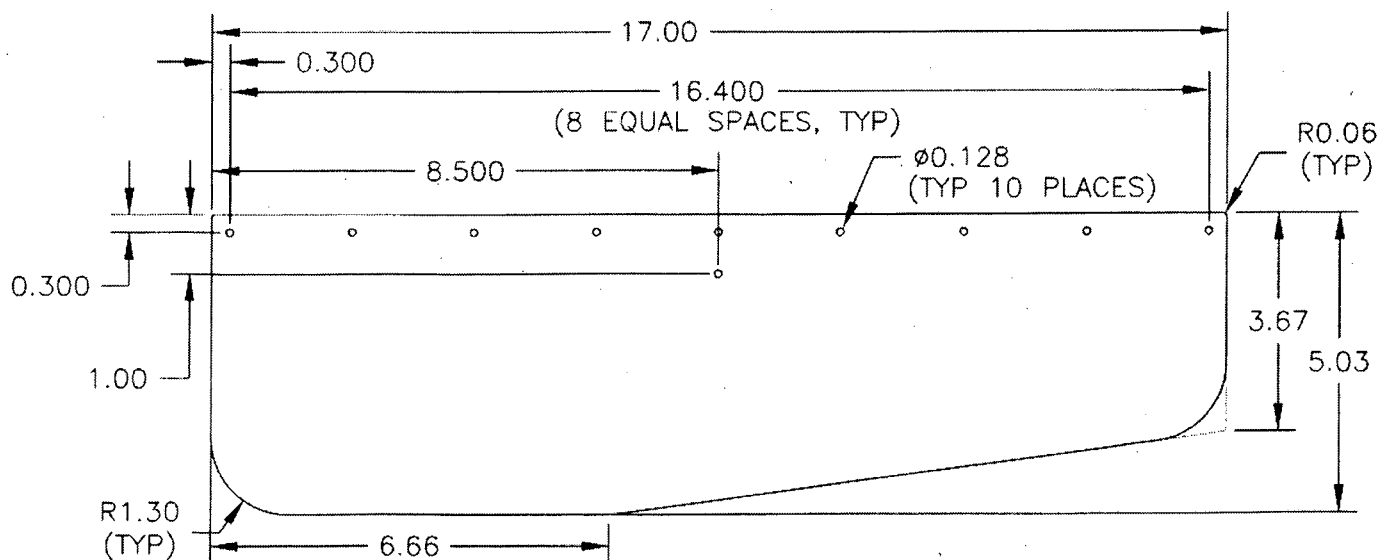
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries